User:

Saturday, 11/5/2005 12:56:58 PM

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 23714A

Estimate Number

: 10209

P.O. Number

: NIA

This Issue

: 11/5/2005

:N/A

: NC : MA

Type

S.O. No. : N/A : LARGE FAB ASSY **Part Number**

Drawing Name

: D3265041

Drawing Number

: D3265 REV B

: 350 BASKET BASE (SHORT)

Project Number Drawing Revision : N/A

Material **Due Date**

: 11/30/2005

Qty:

1 Um:

Each

Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

Previous Run

: Est Rev:C

Re-Format

05-11-03 JLM

COMMENT BELOW

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | |
|---------|-----------------------|--------------------------|---------|-------------|
| 1.0 | D31661 | Basket Hoop | B26259 | AA 06/04/04 |
| 2.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W | M100560 | M 06/04/04 |
| 3.0 | D22323 | Basket Hinge | B25239 | 1 00/04/04 |
| 4.0 | D2325 . | Support Gusset (350 Bask | R 25687 | 1 06/04/04 |
| 5.0 | D23273 | Spacer Bushing | B25823 | MAG/04/04 |
| 6.0 | D2581 | Mounting Bracket | A25834 | N 16/04/04 |
| 7.0 | D34425 | Shim | A24246 | A 06/04/04 |
| 8.0 | M304EX07516F | Expanded Metal Flat Stai | M10058 | M 06/04/04 |
| 9.0 | LARGE FAB 1 | LARGE FABRICATION RESOU | | |

Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

POWDER COATING 11.0

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

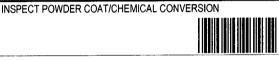




Saturday, 11/5/2005 12:56:59 PM Date: Linda Lacelle User: **Process Sheet** . Drawing Name: 350 BASKET BASE (SHORT) Customer: CU-DAR001 Dart Helicopters Services Job Number: 23714A Part Number: D3265041 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 12.0 HAND FINISHING1 Comment: HAND FI **RESOURCE #1** Seal support gusset seam with White Sikaflex-291 Batch: _ 480 Expiry date:

13.0

QC3



Job Completion



POWDER COAT/CHEMICAL CONVERSION

level

4 Obw4.18



| DART AEROSPACE LTD | Work Order: | 23714 |
|---|--------------|-------------|
| Description: 350 Basket Base (Short) | Part Number: | D3265-041 |
| Dwg: D3265 Rev. A; D2235 Rev. B1 | Qty: | |
| | | Page 1 of 1 |

| | Step | Location | Procedure | Вх | Date | Qty |
|---|------------|-------------|--|------|----------|-----|
| | 1 | DC | Issue Traveler | | -4.6.0. | |
| | | | Dwg not required | 17 M | 85.06.30 | |
| | 2 | ws | Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing. | | | |
| ł | | | (M304TS0.750W.065) Batch: | | | |
| • | | | Cut Qty #/3 D2235-1 from: Qty #/3 D3166-1 Batch: | | | |
| - | 3 | WS | Qty 4 /3 D3166-1 Batch: Drill hole in D3265-3 as per Dwg D3265 | - | | |
| | J | VV3 | Distribute in D3200-3 as per Dwg D3203 | | | |
| İ | 4 | ws | Deburr | | | |
| | | | | | | |
| | 5 <i>A</i> | WS | Pick: | | | |
| | | | Oty Part Number Description Batch | | | |
| | | | 2 D2232-3 Hinge bracket 4 D2325 Support Gusset | | | |
| | | | 4 D2325 Support Gusset 2 D2327-3 Bushing | | | |
| | | | 2 D2581 Bushing Bracket | | | |
| 1 | | , | 26sf M304EX0.75-16F Expanded Metal | | | |
| 4 | 5B | W5 | Remove all MARKINES FROM MATERIAL | 1 | | |
| ſ | 6 | ws | Weld as per Dwg D3265 using Welding Table and corner Jig | | | |
| | | | Deburr as required | | | |
| İ | 7 | QC9/6 | Inspect Welding and Dimensions | | | |
| - | | | T. I. T II. D050 007 047/4 1/D | | | |
| İ | 8 | WS | Take Traveller D350-607-04X to KP | | | |
| ł | 9 | FP | Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 | | | |
| Ì | | ' ' | 1 1 6Wd 61 60dt Willie (161: 4.5.6.2) d5 pc/ d51 665 4.5 | 1 | | |
| Ì | 10 | QC3 | Inspect Powder Coat | | | |
| | | | | | | ٠. |
| ŀ | 11 | FP | Seal support gusset seam with White Sikaflex-291 | | | |
| | | | Batch: | | | |
| - | | 005 | Expiry date: | | | |
| | 12 | QC5 | Inspect work to Step 11 | | | |
| - | 13 | FP | To GA Cell for Assembly | + | | |
| | 10 | | 10 O/L Con for Assortibly | | | , |
| L | | | 1, | | L | · |

| R | lev | Date | Change | Revised By | Apprøved |
|---|-----|----------|-----------|------------|----------|
| | Α | 04.02.02 | New issue | KJ/DS | -# |



04.04.01

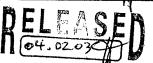
Dart Aerospace Ltd

| W/O: | | | WOF | RK ORDER CHANGES | | | | | |
|---------|--------------|-------------------|---|---------------------------------------|----------------|---------------------------|------------------------|---------------------------------|--------------------------|
| DATE | STEP | PR | OCEDURE CHAN | GE | Ву | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | ر بر هنده است. <u>بر در هنده هنده است. بر در بر بر بر بران پر بر بران پر بر این بران پر بر بر بر بران بر بر بر بر</u> | | | | | 9. | |
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| | | | | | | | | | |
| NCR: | | | WORK ORDE | R NON-CONFORMANO | E (NCR |) | | | |
| | | Description of NC | Corrective Action Section B | | Vorifie | ation | | Approval | |
| DATE | STEP | Section A | Initial Design Mgr | Action Description Design Mgr | Sign & Date | Verification Section C | Approval Design Mgr | Approval QC Inspector | |
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| : (| <u></u> | | | | | | | | |
| Part No | o: | PAR #: | Fault Category: | NCR: Y | es No | DQA: | | Date: | |
| NOTE: D | ate & initia | al all entries | | C | A: N/C CId | sed: | | Date: | |

| DART AEROSPACE LTD | Work Order: | 23714 |
|-------------------------------------|--------------|-------------|
| Description: 350 Basket Lid (Short) | Part Number: | D3266-041 |
| Dwg: D3266 Rev. A D2236 Rev. B1 | Qty: | |
| | | Page 1 of 1 |

| Step | Location | Procedure | Bu | Date | Qty |
|--|----------|--|-----|----------|-----|
| 1 | DC | Issue Traveler | | | , |
| | | Dwg not required | 147 | 05.06.30 | () |
| 2 | WS | Cut 3/4" x 3/4" square tubing as per Dwg D3266 | 0 | | |
| | | Material: 304/316 SS tube .063" wall | | | |
| | | (M304TS0.750W.065) Batch: | | | |
| | | Cut Qty 4 D2236 from: Qty 1 D3166-3 Batch: | l i | | |
| 3 | WS | | | | |
| | VVS | Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305 | | | |
| 4 | WS | Deburr | | | |
| 54 | ws | Pick: | | | |
| 1 | | Qty Part Number Description Batch | | | |
| | | 2 D2232-1 Hinge plate | | | 1 |
| | | 2 D2327-1 Bushing | | | |
| | | 1 D2506 Label Plate 2 D2581 Mounting Bracket | | | |
| J | , | 2 D2581 Mounting Bracket 10sf M304EX0.75-16F Expanded Metal | | | |
| <b< td=""><td>WS</td><td>Printie All MARKINGS FROM Material</td><td></td><td></td><td></td></b<> | WS | Printie All MARKINGS FROM Material | | | |
| 6 | WS | Weld as per Dwg D3266 using Welding Table and corner Jig | | | |
| | | Deburr as required | | | |
| 7 | QC6 & 9 | Inspect Welding and Dimensions | | | |
| 8 | FP | Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 | | | |
| <u></u> | | | | | |
| 9 | FP | Wing Walk Batch: | | | |
| | | and Spray Paint black as per Dwg D3266 | | | |
| 10 | 000 | and QSI 005 4.4 Batch: | | | |
| 10 | QC3 | Inspect Powder Coat and Wing Walk | | | |
| 11 | FP | To GA Cell for Assembly | | | |
| | <u> </u> | | | | - |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|----------------|----------|
| A | 04.02.02 | New issue | KJ/DS | - |



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Dart Aerospace Ltd

| W/O: | | | WO | RK ORDER CHANGES | | | | | |
|---------|------|--------------------------------|----------------|--|-----------|----------|-----------------|---------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CHAN | IGE | Ву | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
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| NOD | | 1 | WORK ORDE | R NON-CONFORMAN | CF (NCF | 5) | | | |
| NCR: | | | | | | ' | | 1 | T |
| DATE | STEP | Description of NC Section A | Initial | Corrective Action Section B Action Description | Sign 8 | | cation ion C | Approval Design Mgr | Approval QC Inspector |
| | | Section A | Design Mgr | Design Mgr | Date | Seci | ion C | Design wigi | QC Inspector |
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| Part No | ·· | ΡΔΩ #• | Fault Category | y NCP· \ | res (No) | DOA: | 30 | Date: ^ | 604/18 |
| | | all entries | uait oatogory | | DA: N/C C | • | | Date: | |